

Work Order ID 109966

December-10-13 7:24:25 AM

ASAD

109966

Page 1

Item ID: D3290-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Exterior Window For -111

Start Date: 12/10/13 Start Qty: 6.00 *6*

Cust Item ID:

Required Date: 12/11/13 Req'd Qty: 6.00 *6*

Customer:

Reference:

Approvals: Process Plan: h Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3290	Rev C

150 Pick Kit 0.00

150

Packaging Memo 0.00

Packaging

(6) SAD 13/12/11

160 Small Fab 0.00

160

Small Fab Memo 0.00

Small Fab

Assemble as per Dwg D3290
Clean D3290-041 and place in plastic wrap

6 SAD 13/12/27

170 QC5- Inspect part completeness to step on W/O 0.00

170

QC Memo 0.00

Quality Control

S 13/12/27

(46)

Work Order ID 109966

December-10-13 7:24:25 AM

109966

Page 2

Item ID: D3290-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Replacement Exterior Window For -111
 Start Date: 12/10/13 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 12/11/13 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>ST219</u>	0.00							
180									
Packaging	Memo	0.00				6x	DAS 28 9-89	13-12-27	
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

Handwritten: 13/12/30
 MF
 13-12-30

Picklist Print

December-10-13 7:24:25 AM

Page 1

Work Order ID: 109966

Parent Item: D3290-041

Parent Item Name: Replacement Exterior Window For -111

Start Date: 12/10/13

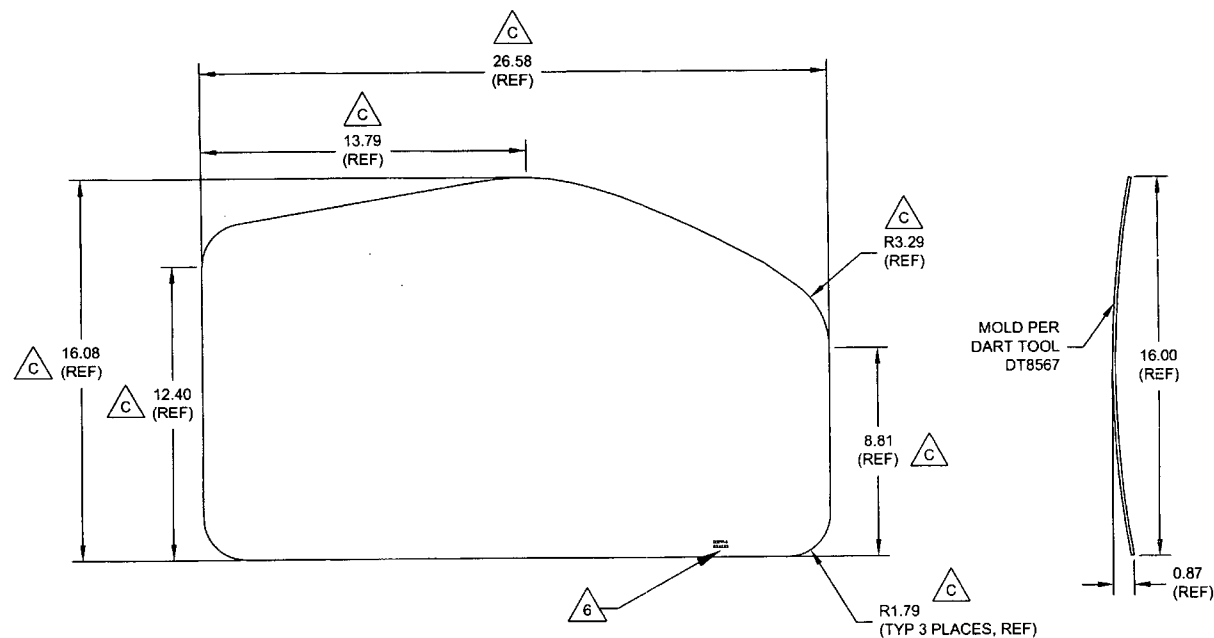
Required Date: 12/11/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP B05.05.25 Added Step 11KJ/JLM
IPP C06.05.09 Ecn 798 EC
IPP Rev:D Now on Waterjet 06-06-16 JLM
IPP rev E rev C dwg 07.09.28 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3290-1 Frame		Manufactured	No			150	Each	6.0000	1	6		12/12/11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST214A		6							
				105296		3							
				107821		3							
D2126 Seal		Manufactured	No			150	f	222.4190	6.5	39		13/12/11	
(D2126-0780) cut qty (1) at 78.00" as per dwg ***per kit***				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST405		222.419							
				102729		182.105							
				89058		40.314							
D3290-3 Window		Manufactured	No			150	Each	9.0000	1	6		13/12/11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST214A		9							
				109517		9							



D3290-3 WINDOW

D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

UNDER REVIEW

**DEO ATTACHED
RELEASED**

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. C
MFG. APPR.	<i>[Signature]</i>	D3290 SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE SCALE
DE APPR.	<i>[Signature]</i>	REPLACEMENT WINDOW ASSEMBLY 1:5
DATE	07.07.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD

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DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>qp</i>	CHECKED <i>h</i>	MFG. APPR. <i>EZ</i>	APPROVED <i>WJ</i>		DE APPR. <i>h</i>		
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21		DATE 09/09/21		

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

D3290-1 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
 OR
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

RELEASED
 2009-10-09
WJ

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